

Date: Monday, 2/4/2008 11:23:16 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 37153	
Estimate Number : 10271	
P.O. Number :	Part Number : D2561
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D2561 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 34357	Material :
Written By : <u>080204</u>	Due Date : 2/11/2008 Qty: 60 Um: Each
Checked & Approved By : <u>080204</u>	
Comment : Est C 00.05.19 Added inspect level 8 EC	
Est Rev:D Now on Waterjet 06-06-14 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .25" x 6.0"



Comment: Qty.: 0.3850 f(s)/Unit Total : 23.1021 f(s)
 Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick
 Batch: 100782 LB 8-2-4
103433X16

70

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2561

Dwg Rev: BProg Rev: B2-Deburr if necessary LB 8-2-5

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1



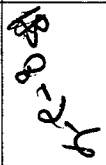
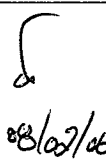
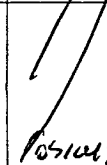

Deburr, no sharp edges

5.1 Inspect QC #5.

08/02/06 70 68
 08/02/06 70 68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/08	11 20	Part scrap due to water jet causing a large cut into the part RL still pressure in water jet as it moved across the part.		Scrap and destroy no replace qty 		 08/02/08		 08/02/08

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT E

AS 08/02/07

(XZ)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(69)

Comment: FINAL INSPECTION/W/O RELEASE

208/02/08

Job Completion



mi 2008/2/07

(69)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

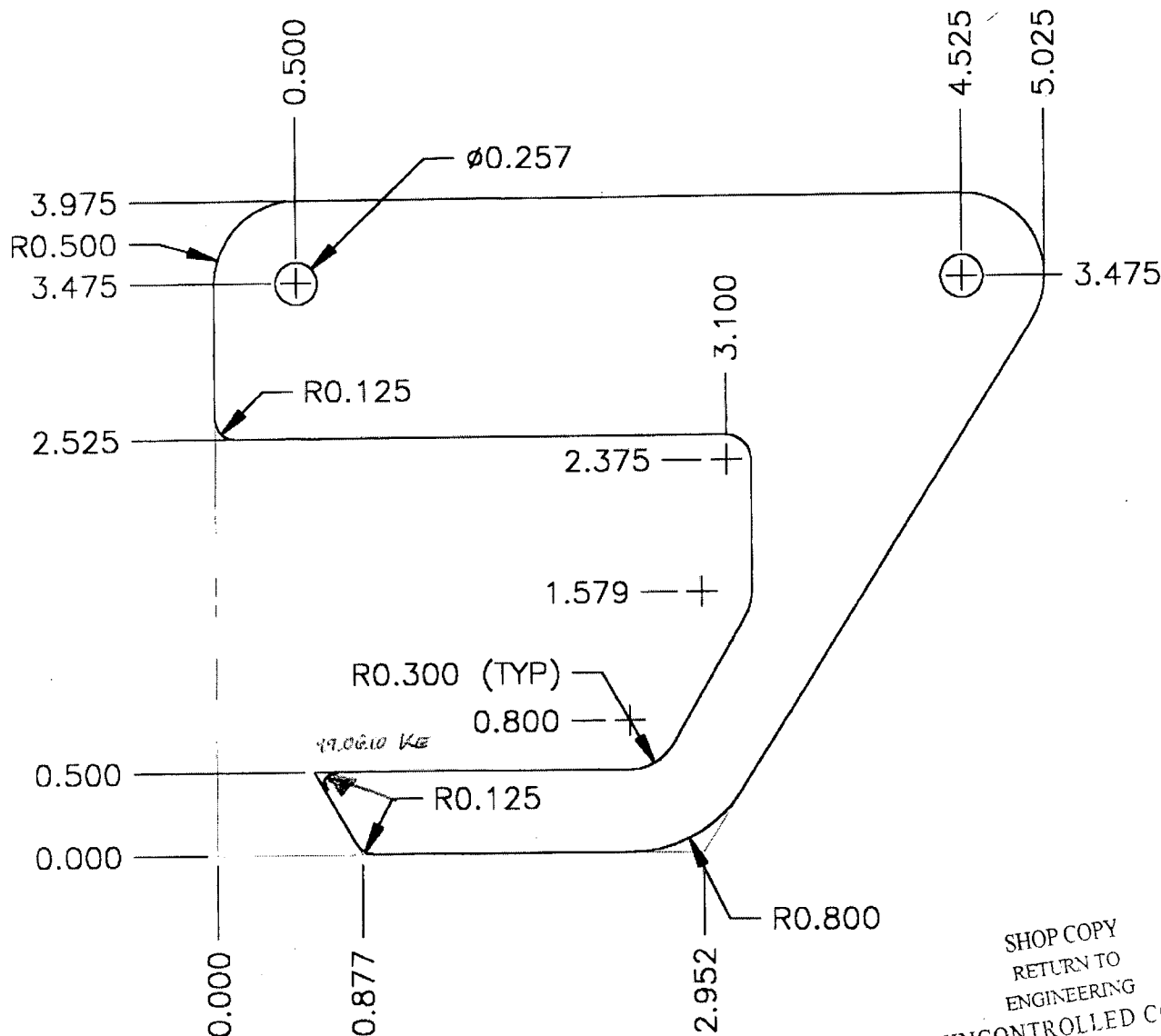
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2561	SHEET 1 OF 1
DATE	TITLE	SCALE	
96.04.26	LUG PLATE	1:1	

RELEASED
96 05 06



MATERIAL: 6061-T6 0.25 THICK
OR 6063-T6 0.25 THICK
OR 5052-H34 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37153